

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019557**Date Inspected:** 15-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Shao Hai Lang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower Lift 5, suspender bracket

PCMK: SD1-BRSA5-1

Weld No. 19B

Welder: 054460

WPS-B-T-3213-TL-U4b

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

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ZPMC QC is identified as Yu Zhi Lai, CWI Ye Yong Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A6-027

Weld No.102

Welder: 040533

WPS-B-T-2332-TC-PA-7

Component; Bike Path

PCMK: BK004A6-027

Weld No.098

Welder: 052075

WPS-B-T-2333-TC-PA-7

Component; Bike Path

PCMK: BK004A8-027

Weld No.102

Welder: 053860

WPS-B-T-2332-TC-PA-7

Component; Bike Path

PCMK: BK004A8-027

Weld No.070,078

Welder: 040302

WPS-B-T-2333-TC-PA-7

Bay 14 West Line

This QA Inspector observed the following work in progress for Bay 14 west line.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xu.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG13AW

PCMK: SEG3013K/L

Weld No. 003

Welders: 202122, 047866

WPS-B-T-2232-TC-U4b-F

Component; OBG13AW

PCMK: SEG3013M

Weld No. 219, 260

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Welders: 066733, 066398
WPS-B-T-2232-TC-U4b-F

Component; OBG13AW
PCMK: SEG3013H
Weld No. 071, 072
Welders: 066674, 066763
WPS-B-T-2232-TC-U4b-F

Component; OBG13AW
PCMK: SEG3013C
Weld No. 161
Welder: 066439
WPS-B-T-2232-TC-U4b-F

Component; OBG13AW
PCMK: SEG3013F
Weld No. 072
Welder: 067888
WPS-B-T-2232-TC-U4b-F

Component; OBG13AW
PCMK: SEG3013Y
Weld No. 092, 093
Welder: 069683
WPS-B-T-2132

Component; OBG13AW
PCMK: SEG3013X
Weld No. 379, 380
Welder: 067601
WPS-B-T-2132

Bay 14 East Line

This QA Inspector observed the following work in progress for Bay 14 east line.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Ji Cai Feng, CWI Yu Jiao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG13AE
PCMK: SEG3007K
Weld No. 030, 031, 032
Welder: 044824

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WPS-B-T-2132

This QA Inspector observed the following work in progress for Bay 14 east line.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ji Cai Feng, CWI Yu Jiao.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG13BE

PCMK: SEG3009D

Weld No. 067, 072, 077, 082, 087, 092

Welder: 043661, 200113

WPS-B-T-2213-TC-U4b-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
